

Work Order ID 78903

78903

Page 1

January-17-12 11:52:39 AM

Item ID: D2232-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Hinge
 Start Date: 17/01/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 31/01/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: M.L.J. Date: 12/01/12 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2232	Rev C								

100 0.00
100 FLOW WATER JET
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D2232 Dwg Rev: C Prog Rev: C 2-
 Deburr if necessary

B 12-1-25

(18)

110 0.00
110 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00
 Quality Control

B 12-1-25

120 0.00
120 QC8- Inspect parts - second check
 QC Memo 0.00
 Quality Control

512/1/26

(18)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Debur								
140 *140* Packaging	Identify as per dwg & Stock Location: WA	0.00							
Packaging	Memo	0.00							
Packaging	*****STOCK IN BASKET CELL*****								
150 *150* QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

Pl 12-01-27 13X

12/1/30

12-01-27 (18)

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 78903

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Parent Item: D2232-3

D2232-3

Parent Item Name: Basket Hinge

Start Date: 17/01/2012

Required Date: 31/01/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP B01.06.07Now laser cutEC
IPP Rev:C Now on Waterjet 06-10-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S11GA

Purchased

No

100

sf

51.1000

0.0694

0.876632

1.5

M304S11GA

**

B 12-1-25

304/316 0.125 Sheet

Location

Loc Qty

Loc Code

MAT020

51.1

119048

19.1

120243

32

119048

18

W/O:		WORK ORDER CHANGES					
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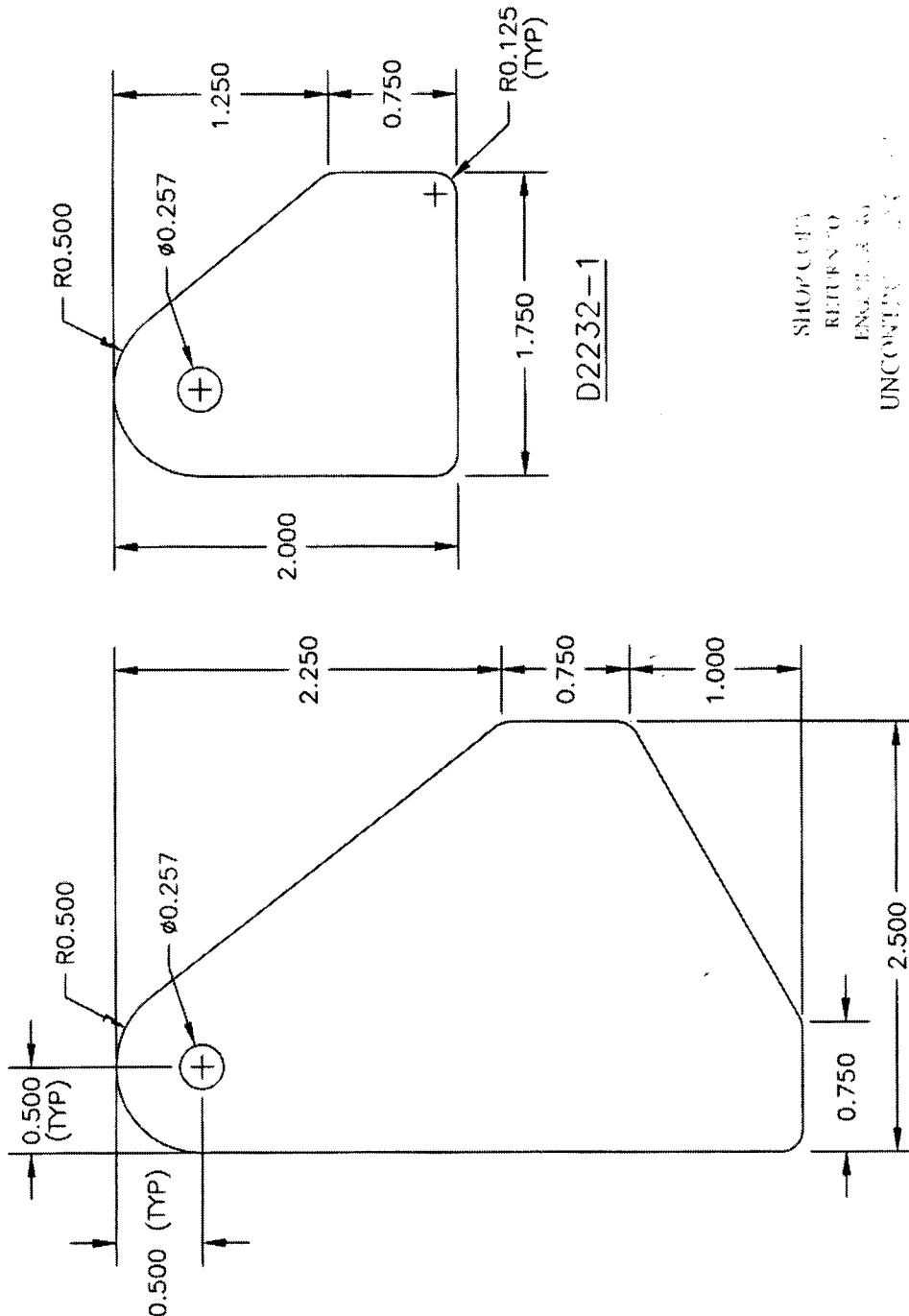
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NOTE: Date & initial all entries



DESIGN	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>WIB</i>	APPROVED <i>KE</i>	DRAWING NO. D2232	REV. C SHEET 1 OF 2
DATE 98.04.28	TITLE BASKET HINGE		SCALE 1:1
A	94.05.12	NEW ISSUE	
B	96.01.02	ADDED -5 AND -7	
C	98.04.28	0.125 THICK WAS 0.063	

RELEASED
98.05.05 KE



SHOUPCHES
RETURN TO
ENGINEER
UNCOMPLETED
SUBMIT TO

WORK CENTER
NO. 389.03. H.L.J.

12/01/17

MATERIAL: AISI 304/316 SS 0.125 THICK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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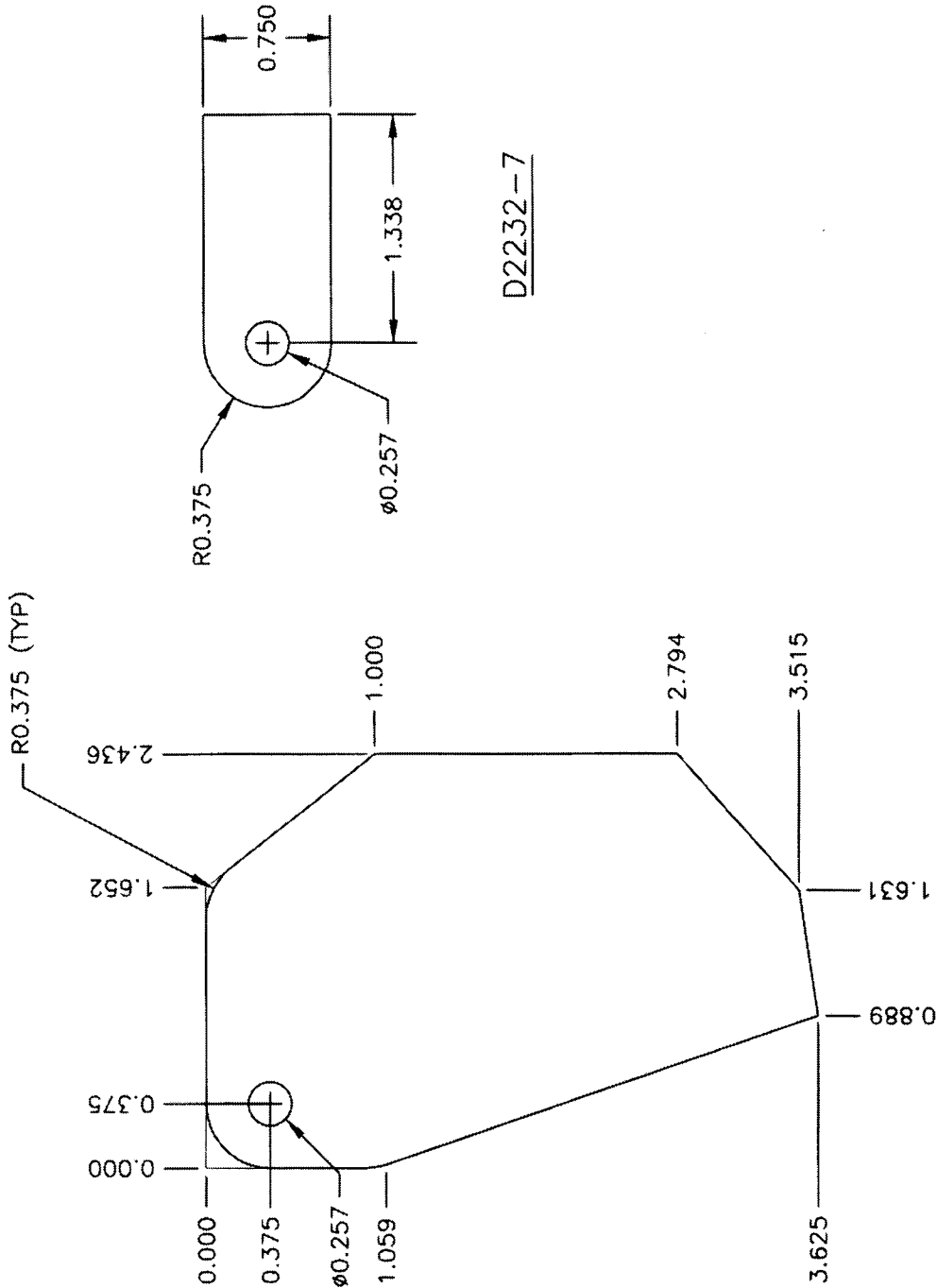
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DESIGN <i>[Signature]</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2232	REV. C SHEET 2 OF 2
DATE 98.04.28		TITLE BASKET HINGE	SCALE 1:1

RELEASED
98.05.05 KE



D2232-7

D2232-5

MATERIAL: AISI 304/316 SS 0.125 THICK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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